

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services			Drawing Name: HELI-ACCESS STEP LH (FOLDING)
Job Number: 33998		Part Number: D412630033	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
5.0	D2807	Gas Spring (Support Prop)	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)		<i>* U/N ON INSTALL, REVERSE ORIENTATION OF GAS SPRING *</i>	
Support Prop			
Pick:			
Qty	Part Number	Description	Batch
2	D2807	Gas Spring	<i>35962</i>
6.0	D2813	Washer	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)			
Washer			
Pick:			
Qty	Part Number	Description	Batch
2	D2813	Washer	<i>B32776</i>
7.0	D3562041	STEP ASSEMBLY, LH	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)			
Step Weldment LH			
Pick:			
Qty	Part Number	Description	Batch
1	D3562-041	Step Weldment LH	<i>B35621</i>
8.0	D33951	Bushing	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)			
Bushing			
Pick:			
Qty	Part Number	Description	Batch
4	D3395-1	Bushing	<i>B33578</i>
9.0	AN3C21A	BOLT	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)			
BOLT			
Pick:			
Qty	Part Number	Description	Batch
2	AN3C21A	Bolt	<i>M101159</i>

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/11/2007 2:45:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 33998

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0 AN8C16 Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN8C16	Bolt	M102736

AS 07/12/27 ③

11.0 AN310C8 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description	Batch
2	AN310C8	Nut	M104679

AS 07/12/27 M105426 X1

③

12.0 MS24665302 Cotter Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description	Batch
2	MS24665-302	Cotter Pin (or AN380C3-4)	M16941

AS 07/12/27 ③

13.0 NAS1515H3 Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
6	NAS1515H3	Washer	M105164

AS 07/12/27 ③

14.0 NAS1515H5L WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
4	NAS1515H5L	Washer	M105792

AS 07/12/27 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

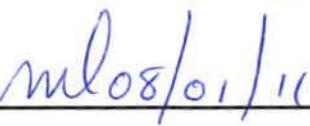
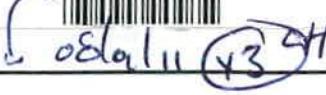
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/11/2007 2:45:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: HELI-ACCESS STEP LH (FOLDING)
Job Number: 33998		Part Number: D412630033
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
15.0	NAS1515H8 	Washer
		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)		
Washer		
Pick:		
Qty	Part Number	Description
4	NAS1515H8	Washer
16.0	MS210433 	Nut
		
Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)		
Nut		
Pick:		
Qty	Part Number	Description
4	MS21043-3	Nut
17.0	MS24693C280 	Screw
		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)		
Screw		
Pick:		
Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)
18.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1		
Assemble as per dwg D412-630 p.14		
Coat all hardware with LPS3 rust inhibitor		
A/R LPS3 batch: <u>M104929</u> 		
COAT exposed HARDWARE WITH LPS PROCYON.		
A/R LPS PROCYON BATCH: <u>M17045</u> 		
19.0	QC5 	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/11/2007 2:45:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 33998

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
20.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
21.0	D28061	Bushing
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing Pick: Packing Kit	
	Qty Part Number Description Batch	
	2 D2806-1 Bushing	33590 ✓ AS 07/12/27 (X3)
22.0	D28063	Bushing
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Bushing Pick: Packing Kit	
	Qty Part Number Description Batch	
	2 D2806-3 Bushing	D27286 x5 D36534 x1 AS 08/01/10 (X3)
23.0	D28105	Strut
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Strut Pick: Packing Kit	
	Qty Part Number Description Batch	
	1 D2810-5 Strut	B32778 (X3) B35829 x2 AS 07/12/27 (X3)
24.0	D33961	Spacer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Spacer Pick: Packing Kit	
	Qty Part Number Description Batch	
	2 D3396-1 Spacer	B329496 (X8) B34025 (X1) AS 07/12/27 (X3)
25.0	AN4C6A	Bolt
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bolt Pick: Packing Kit	
	Qty Part Number Description Batch	
	1 AN4C6A Bolt	M105793 ✓ AS 07/12/27 (X3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/11/2007 2:45:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 33998

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	AN4C6A	Bolt
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26.0 AN4C10A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	M101189 ✓



AS 07/12/27 (5)

27.0 AN4C15A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	M103915 ✓



AS 07/12/27 (5)

28.0 AN44C7A Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN44-C7A	Eyebolt	M101711 ✓



AS 07/12/27 (5)

29.0 AN5C15A Bolt



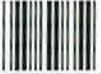
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	M105125 (x2)

M10129 (x1)



AS 07/12/27 (5)

30.0 NAS1515H4 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	M105516 ✓

AS 07/12/27 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: P Date: 08/06/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 28/11/2007 2:45:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 33998

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0 NAS1515H5 Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H5	Washer	M105792 ✓

AS 07/12/27 (3)

32.0 MS210434 Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
4	MS21043-4	Nut	M106421 ✓

AS 07/12/27 (3)

33.0 MS210435 Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description	Batch
3	MS21043-5	Nut	M105430 ✓

AS 07/12/27 (3)

34.0 QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/01/14 (3)

35.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location: A

PPP Rev: A

8/1/14 50 (3)

36.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/01/14

Job Completion



11 08/01/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date: Monday, 8/20/2007 3:44:23 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	HELI-ACCESS STEP LH (FOLDING)		
Job Number	33998			Part Number	D412630033		
Estimate Number	12567			Drawing Number	IIN UNDER REVIEW		
P.O. Number	:			Project Number	N/A		
This Issue	8/20/2007	S.O. No.	:	Drawing Revision	K		
Prsht Rev.	NC			Material	:		
First Issue	8/16/2007	Type	LARGE FAB ASSY	Due Date	9/5/2007	Qty:	5 Um: Each
Previous Run	33576						
Written By	:						
Checked & Approved By	:						
Comment	Est. Rev:A New Issue 06-11-08 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:		
1.0	DC	DOCUMENT CONTROL		
	Comment: DOCUMENT CONTROL Photocopy bluefile & create labels per PPP D412-630-033 CHG002			07.08.29/09
2.0	D2012107	Clevis		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Clevis Pick: Qty Part Number Description Batch			
	1 D2012-107 Clevis			
3.0	D2803041	Bracket Assembly		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch			
	1 D2803-041 Bracket Assembly LH			
4.0	D2804041	Bracket Assembly		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Bracket Assembly Pick: Qty Part Number Description Batch			
	1 D2804-041 Bracket Assembly LH			
				REFERENCE ONLY
Job Completion				

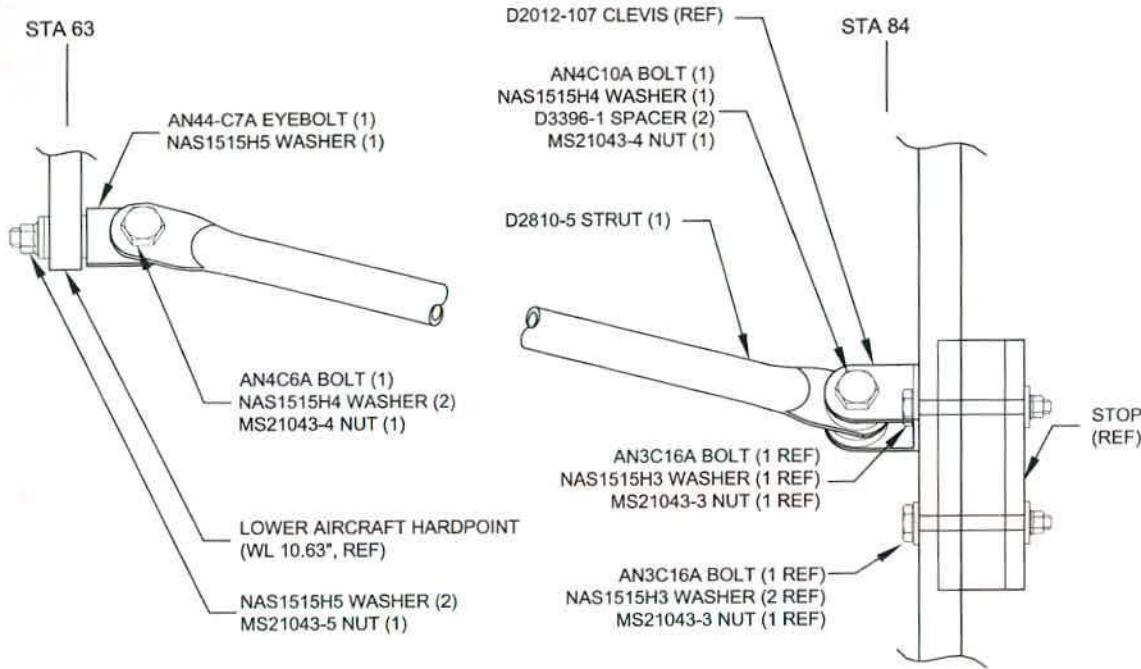


FIGURE 16 – Strut Detail for D412-630-033/-034 *Heli-Access-Step™* Installation
(NOT TO SCALE)

Mo 33998

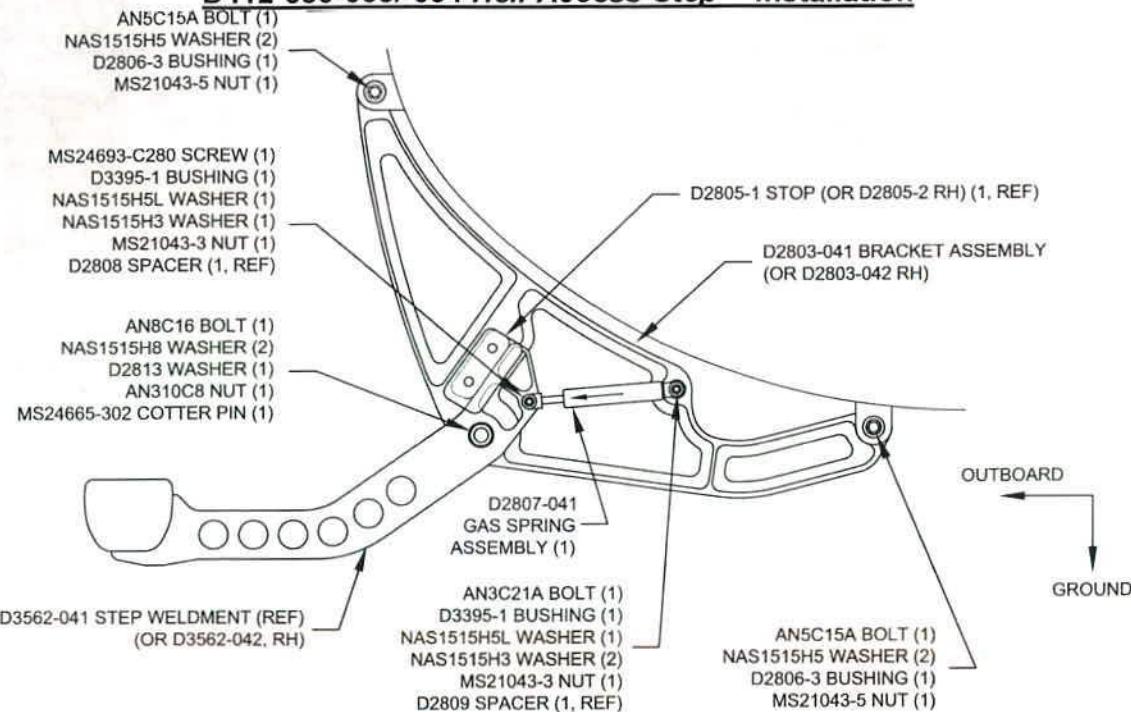
D412-630-033/-034 Heli-Access-Step™ Installation

FIGURE 14 – STA 84.29 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)

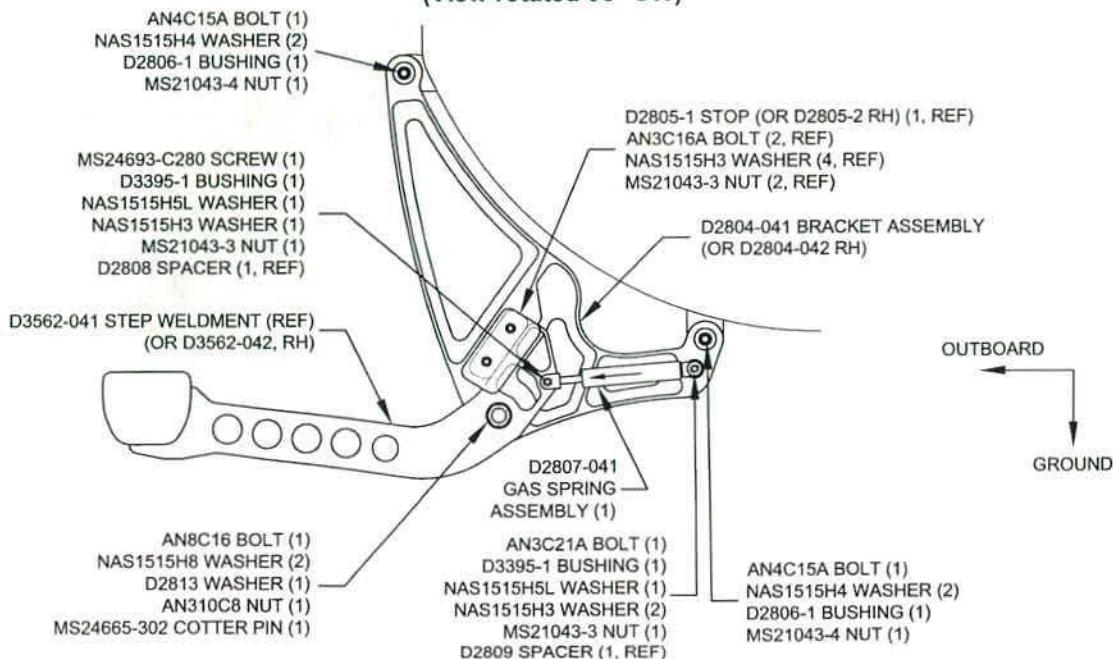


FIGURE 15 – STA 155.06 for D412-630-033/-034 Heli-Access-Step™ Installation
(View rotated 90° CW)